



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5467-1
Job Sheet 188000



Part No: D5467-1

Job Qty: 10 pcs

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	2/20/19		0.00	14.01	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/02/17
							HAAS - 4		
120	QC 1	10 pcs	2/20/19		0.00	0.00	QC 1 - 14		
							QC 1 - 35		
							QC 1 - 8		
							QC 1 - 9		SBL 19/02/17
130	QC 8	10 pcs	2/20/19		0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 38		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		SBL 19/02/17
							QC 8 - 58		
140	Handfinish - 1-1 Chemical-B4B	10 pcs	2/20/19		0.00	3.01	QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							Handfinish - 1 - 1 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S154497



Part: D5467-1

Job No: 188000

Serial No/Batch: S154497

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/17/19

					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R.19/2/25
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Spray Paint - 2 - B4B	10 pcs	2/20/19	0.00 0.24	Spray Paint - 1 - B4B	AB 19-2-28
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
160	QC 14	10 pcs	2/20/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 38	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
170	Packaging 3-1 - Stock - B4B	10 pcs	2/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
						Plex 1/30/19 4:26 PM Dart.Hadley.Shannon

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	5+399 MAR 13 2019
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180	QC 21 - SA	10	2/20/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					MAR 13 2019
Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Descriptions: Folio FB550 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB550 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB550 and inspect 120 - (QC1- Inspection performed by CMM) Inspect on CMM as per folio CMM022. DWG REV: _____ CMM PROG. REV: _____ 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS					

PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: S152590 2-PAINT AS PER DWG AND QSI005 4.2.2.4
PAINT BATCH: S146086

160 - (QC14- Inspect Spray Paint)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	10 pcs (1 ea)	100-HAAS 4 Axis	9X S133600 1X S147787

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	D6101-007	10	33	0

Part Specifications

Specifications could not be found.

Plex 1/30/19 4:26 PM Dart.Hadley.Shannon



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Job Sheet 188000



Part No: D5467-1

Job Qty: 10 ea

Part Name: Saddle, Fwd, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/31/18

Job Tracking No:

Due Date: 2/20/19

Created By: Jesse White

Type: Stock

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	2/20/19	2/20/19	0.00	0.00	Start Up Machining-4		
100	CNC Vertical Machining	10 pcs	2/20/19	2/20/19	0.00	14.01	HAAS1-1		
120	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC1		
130	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC8 Machining-4		
140	HandFinish	10 pcs	2/20/19	2/20/19	0.00	3.01	HandFinish1		
150	SprayPaint	10 pcs	2/20/19	2/20/19	0.00	0.24	Spray Paint		
160	QC	10 pcs	2/20/19	2/20/19	0.00	0.00	QC14		
170	Packaging	10 pcs	2/20/19	2/20/19	0.00	0.00	Packaging3-2		
180	QC21-SA	10 Ea	2/20/19	2/20/19	0.00	0.00	QC21		

Part Op 100 - Program Batch No. _____ Double check by: _____ 1-Machine Step No 1 per Folio FB550 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FB550 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FB550 and inspect

120 - Inspect on CMM as per folio CMM022. DWG REV: _____ CMM PROG. REV: _____

150 - ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT BATCH: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	10 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	10	13	0

Part Specifications

Specifications could not be found.

Plex 12/31/18 1:00 PM dart.white.jesse

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 188000
Description: Saddle, Fwd, out		Part Number: D5467-1
Inspection Dwg: D5467-1	Rev: A	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.438	0.443	-	0.438	.438	.438	.438	
B	1.745	1.755	-	1.750	1.750	1.750	1.750	
C	3.495	3.505	-	3.500	3.500	3.500	3.500	
D	1.745	1.755	-	1.750	1.750	1.750	1.750	
E	7.990	8.010	-	8.000	7.999	8.000	8.000	8.000
F	0.490	0.510	-	0.502	.502	.498		
G	0.257	0.262	-	0.257	0.257	0.257	0.257	.257
H	0.375	0.380	-	0.375	0.375	0.375	0.375	.375
I	0.490	0.510	-	0.501	0.500	.499	.500	.500
J	1.174	1.184	-	1.179	1.179	1.179	1.179	1.179
K	0.538	0.578	-	0.5685	0.5705	.568	.567	.569
L	1.174	1.184	-	1.179	1.179	1.179	1.179	1.179
M	1.490	1.500	-	1.495	1.495	1.495	1.495	1.495
N	2.495	2.505	-	2.500	2.500	2.500	2.500	2.500
O	3.869	3.879	-	3.874	3.874	3.874	3.874	3.874
P	0.115	0.135	-	0.133	0.133	.133	.130	.128
Q	0.115	0.135	-	0.126	0.126	0.1245	0.126	.125
R	0.240	0.260	-	0.252	0.254	0.252	0.254	.252
S	0.115	0.135	-	0.132	0.132	.130	.131	.130
T	0.188	0.198	-	0.188	0.188	0.188	0.188	.188
U	2.940	2.980	-	2.960	2.960	2.960	2.960	2.960
V	0.230	0.250	-	0.245	0.248	.245	.241	.242
W	0.115	0.135	-	0.122	0.124	.124	.126	.127
AI	2.000	2.020	-	2.000	2.000	2.000	2.000	2.000
Y								
Z	0.352	0.372	-	0.361	.362	.363	.364	
AA	0.470	0.530	-	0.500	0.500	.500	.500	.500
AB	0.615	0.635	-	0.628	.625	.625	.625	
AC	0.053	0.073	-	0.063	0.061	.063	.060	.062
AD	0.240	0.260	-	0.251	0.257	.255	.251	.252
AE	1.385	1.395	-	1.386	1.386	.1386	.1386	.1386
AF	0.115	0.135	-	0.130	0.130	.128	.130	.127
AG	0.240	0.260	-	0.250	0.250	.245	.245	.247
AH	0.240	0.260	-	0.250	0.250	.253	.253	.252
Accept/Reject								

Measured by:		Date:	
Audited by:	mml	Date:	19/02/25
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 188000
Description: Saddle, Fwd, out		Part Number: D5467-1
Inspection Dwg: D5467-1	Rev: A	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.438	0.443		.438	.438	.438	.438	.438
B	1.745	1.755		1.750	1.750	1.750	1.750	1.750
C	3.495	3.505		3.500	3.500	3.500	3.500	3.500
D	1.745	1.755		1.750	1.750	1.750	1.750	1.750
E	7.990	8.010		8.000	8.000	8.000	8.000	8.000
F	0.490	0.510		.490	.497	.499	.497	.497
G	0.257	0.262		.257	.257	.257	.257	.257
H	0.375	0.380		.378	.378	.378	.378	.378
I	0.490	0.510		.500	.500	.499	.500	.500
J	1.174	1.184		1.179	1.179	1.179	1.179	1.179
K	0.558	0.573		.569	.568	.568	.568	.569
L	1.174	1.184		1.179	1.179	1.179	1.179	1.179
M	1.490	1.500		1.495	1.495	1.495	1.495	1.495
N	2.495	2.505		2.500	2.500	2.500	2.500	2.500
O	3.869	3.879		3.874	3.874	3.874	3.874	3.874
P	0.115	0.135		.130	.128	.131	.133	.130
Q	0.115	0.135		.126	.125	.125	.124	.125
R	0.240	0.260		.253	.251	.253	.252	.252
S	0.115	0.135		.132	.131	.131	.132	.132
T	0.188	0.198		.188	.188	.188	.188	.188
U	2.940	2.980		2.960	2.960	2.960	2.960	2.960
V	0.230	0.250		.242	.242	.243	.242	.242
W	0.115	0.135		.126	.125	.127	.127	.127
AI	2.000	2.020		2.000	2.000	2.000	2.00	2.000
Y								
Z	0.352	0.372		.364	.363	.363	.364	.364
AA	0.470	0.530		.500	.500	.500	.500	.500
AB	0.615	0.635		.625	.626	.625	.625	.625
AC	0.053	0.073		.063	.063	.067	.064	.064
AD	0.240	0.260		.252	.252	.254	.253	.253
AE	1.385	1.395		1.386	1.386	1.386	1.386	1.386
AF	0.115	0.135		.135	.132	.128	.130	.130
AG	0.240	0.260		.250	.250	.250	.250	.250
AH	0.240	0.260		.250	.252	.253	.252	.252

DAS 57 Accept/Reject

Measured by: 57	Date: 19/02/22
Audited by: mmc	Date: 19/02/25
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 188000
Description: Saddle, End, out		Part Number: D5467-1
Inspection Dwg: D5467-1	Rev: A	DSK: Rev: Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.438	0.443						
B	1.745	1.755						
C	3.495	3.505						
D	1.745	1.755						
E	7.990	8.010						
F	0.490	0.510						
G	0.257	0.262						
H	0.375	0.380						
I	0.490	0.510						
J	1.174	1.184						
K	0.558	0.578						
L	1.174	1.184						
M	1.490	1.500						
N	2.495	2.505						
O	3.869	3.879						
P	0.115	0.135						
Q	0.115	0.135						
R	0.240	0.260						
S	0.115	0.135						
T	0.188	0.198						
U	2.940	2.980						
V	0.230	0.250						
W	0.115	0.135						
AI	2.000	2.020						
Y								
Z	0.352	0.372						
AA	0.470	0.530						
AB	0.615	0.635						
AC	0.053	0.073						
AD	0.240	0.260						
AE	1.385	1.395						
AF	0.715	0.735						
AG	0.240	0.260						
AH	0.240	0.260						
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Preliminary Approval:		Date:	

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A	02.12.12	New Issue	KJ/RF	
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C	12.07.31	Prototype revised to preliminary	KJ	